



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D3954-1

Job Sheet 184765



Part No: D3954-1

Job Qty: 6 ea

Part Name: GWT Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 11/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEETS 1,2 IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 6 Ea  |            | 11/13/18 | 0.00      | 0.00    | Start Up Machining-2  |           |          |
| 100   | Doosan             | 6 pcs |            | 11/13/18 | 0.00      | 1.17    | Doosan                |           |          |
| 120   | QC                 | 6 pcs |            | 11/13/18 | 0.00      | 0.00    | QC8                   |           |          |
| 150   | Packaging          | 6 pcs |            | 11/13/18 | 0.00      | 0.00    | Packaging3-2          |           |          |
| 160   | QC21-SA            | 6 Ea  |            | 11/13/18 | 0.00      | 0.00    | QC21                  |           |          |

Part Op Descriptions: 100 - 1-Turn as per folio FA824 & dwg D3954 FOLIO REV: \_\_\_\_\_ DWG REV: \_\_\_\_\_ 2-Deburr as required

### Job BOM

| Part / Item | Component Name     | Quantity           | Operation             | Container |
|-------------|--------------------|--------------------|-----------------------|-----------|
| M303R1.000  | 303 Round Bar 1.00 | 1.4400 ft (.24 ea) | 90-Start up Operation | S110764   |

### Job Allocations

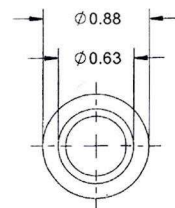
| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M303R1.000     | 1        | 40        | 0         |

### Part Specifications

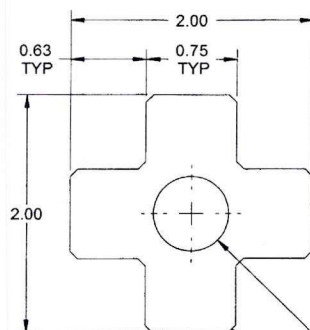
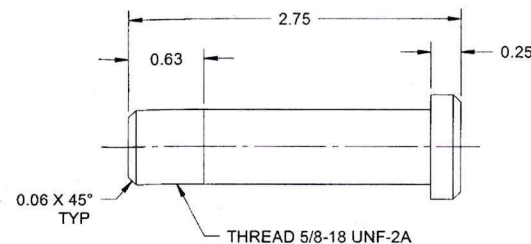
| Spec No | Description | Target/Tolerance      | Limits           | Type     | Special Comments |
|---------|-------------|-----------------------|------------------|----------|------------------|
| 1       | GWT Pin     | 0.880Inches ± 0.030   | 0.910<br>0.850   | Diameter | .880             |
| 2       | GWT Pin     | Attribute             |                  | Diameter |                  |
| 3       | GWT Pin     | 0.060Inches ± 0.030   | 0.090<br>0.030   |          | .062             |
| 4       | GWT Pin     | 45.000Degrees ± 0.500 | 45.500<br>44.500 | angle    | 45°              |
| 5       | GWT Pin     | 0.630Inches ± 0.030   | 0.660<br>0.600   |          | .619             |
| 6       | GWT Pin     | 2.750Inches ± 0.030   | 2.780<br>2.720   |          | 2.751            |
| 7       | GWT Pin     | 0.250Inches ± 0.030   | 0.280<br>0.220   |          | .250             |





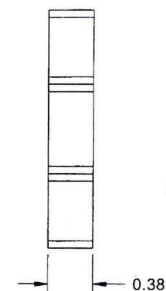


**D3954-1 GWT PIN**



**D3954-3 GWT KNOB**

THREAD 5/8-18 UNF-2B THRU  
0.06 X 45°  
TYP



**NOTES:**

- 1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR  
PER ASTM A582 (303) OR ASTM A276 (304/316)  
REF DART SPEC M303R OR M304R  
-3: AISI 303/304/316 STAINLESS STEEL SHEET  
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)  
OR ASTM A240 OR ASME SA240  
REF DART SPEC M303S OR M304S  
OR:  
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE  
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)  
REF DART SPEC M303B OR M304B
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2  
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3  $\triangle$
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT -1: 0.26 lbs  
-3: 0.23 lbs

**RELEASED**  
2012-10-01  
m

|            |                 |                                                                                                                                                                                                                                                                                                  |              |
|------------|-----------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | AJS/DSTOW       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                        |              |
| DRAWN      | <i>DC</i>       | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                      |              |
| CHECKED    | <i>AS</i>       | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. D       |
| MFG. APPR. | <i>AS</i>       | <b>D3954</b>                                                                                                                                                                                                                                                                                     | SHEET 2 OF 3 |
| APPROVED   | <i>MP</i>       | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   | N/A             | <b>MISC MACHINED PARTS GWT KIT</b>                                                                                                                                                                                                                                                               | NTS          |
| DATE       | <b>12.08.10</b> | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |